

Date: Wednesday, 3/8/2006 10:37:39 AM  
 User: Kim Johnston

## Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
 Job Number : 26104  
 Estimate Number : 10268  
 P.O. Number : N/A Part Number : D350636014  
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : D2750 REV C1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C1  
 Previous Run : 26103 Material : N/A  
 Written By : *See COMMENT Below* Due Date : 4/15/2006 Qty: 1 Um: Each  
 Checked & Approved By : *06.03.08*  
 Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ  
 Est Rev:H 05.12.08 Rearranged procedure steps EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 001

Dt 06/03/21

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B25384

Dt 06-03-10

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap

B24672 BE

Dt 06-03-14

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end

Dt 06-03-10

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330

Dt 06-03-10

\*\*\*\*\*Drill last hole using Dt 8820 locating off last hole drilled\*\*\*\*\*

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size

Dt 06-03-14

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-4),mark Fwd end for cutting using Drill Jig *pm 06-03-14 (1)*  
DT8150,then drill both sides.

5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330 *pm 06-03-14 (1)*  
\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open holes to .500" as per detail "B&C". *pm 06-03-14 (1)*

7-Open holes to .375"mas per detail "D" *pm 06-03-14 (1)*

8-Cut fwd end of tube as per Dwg D2750 *pm 06-03-14 (1)*

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail *pm 06-03-14 (1)*  
A

10-Open holes to .391" as per detail "D". *pm 06-03-14 (1)*

11-Deburr *pm 06-03-14 (1)*

12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod ~~D2744~~ *m 19/00 BE 06-03-14 (1)*

13-Grind welds flush as per Dwg D2750 *BE 06-03-14 (1)*

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *BE 06-03-15 (1)*

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2739 Web

*326207 BE 06-03-16 (1)*

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743

Crossbolt spacer

*B24641*

*BE 06-03-17*

*①*

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625"  $\pm$  holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *BE 06-03-16 ①*

2-Deburr and blow out all chips from inside of tube

*BE 06-03-16 ①*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

*M19597*

*BE 06-03-16*

*④ 4.30*

Sikaflex expire date: *06-06-18*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004.

A/R Aluminum Rod

*M19100 BE 06-03-17 ①*

5-Grind welds flush as per Dwg D2750

*BE 06-03-17 ①*

6-Spot face ground handling holes  $\pm$ 0.750" (8 places)

*BE 06-03-17 ①*

7-Deburr holes

*BE 06-03-17 ①*

10.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

*BE 06-03-22*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*DL 06/05/01 ①*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*DL 06-03-22 ①*

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D27422

Blade Fitting, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, RH	B24640

14.0

AN835A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576

15.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

16.0

MS21083N8

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19185

17.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B24843-2

18.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B25964

DL 06/05/02 ①

Date: Wednesday, 3/8/2006 10:37:40 AM  
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Job Number: 26104

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B25330 ✓

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B25841 ✓

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 ✓	Insert	M18293 ✓
	(or AKS4-1032-225)		
	(or ALS7-1032-225)		
	(or AKS7-1032-225)		

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M18235 ✓

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M15205

DC 06/05/02 ①

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B24879

26.0

AN644A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M19073

27.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614

28.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

DL 06/05/02 ①

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Job Number: 26104

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M16066

DL 06/05/02 (1)

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291 M100480

Sikaflex expire date: 11/06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291 M100480

Sikaflex expire date: 11/06

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

DL 06/05/02 (1)

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
1	D2741	Blade	B24750

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Job Number: 26104

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

34.0 AN960JD816 1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

2 AN960JD816 Washer M16956 ✓

35.0 MS21083N8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

2 MS21083N8 Nut M19099 ✓

36.0 AN816A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

2 AN8-16A Bolt M5760 ✓

AL 06/05/02

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev 1 12/9/02 (1)

39.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q 12/05/03 (1)

Job Completion



U 12/05/03



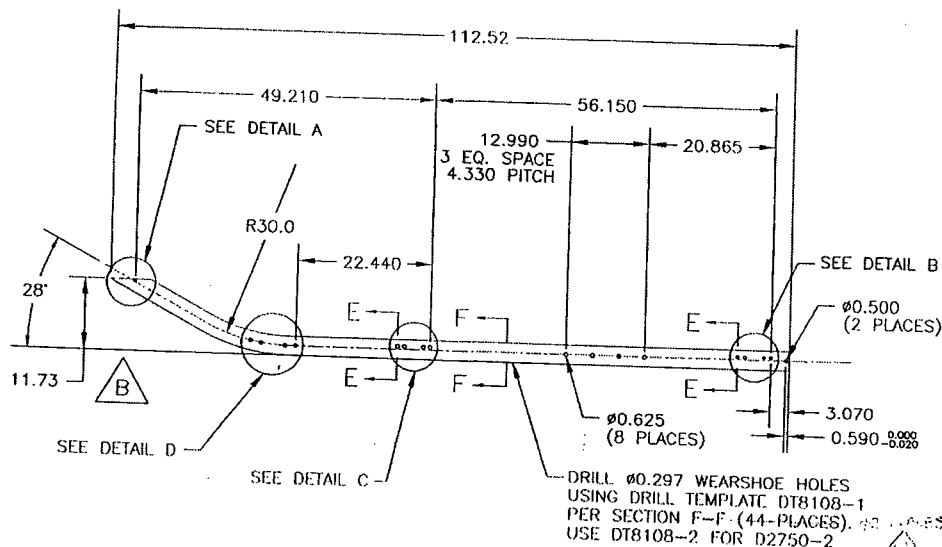


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98.12.16 DS

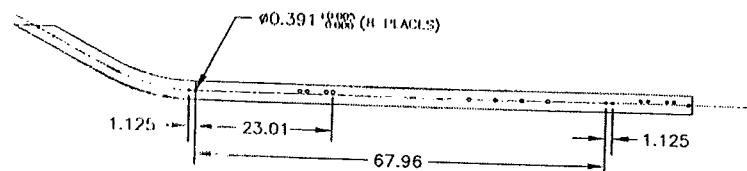
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
C1	95.01.20	CHANGE BY HEADHOLE HOLES, AS MANUFACTURED	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44	44	44	44	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT
42	42	42	42		

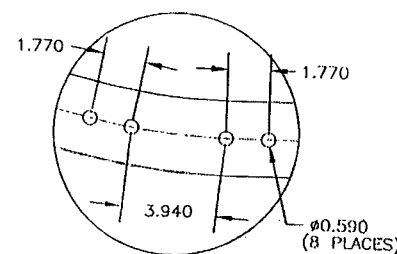
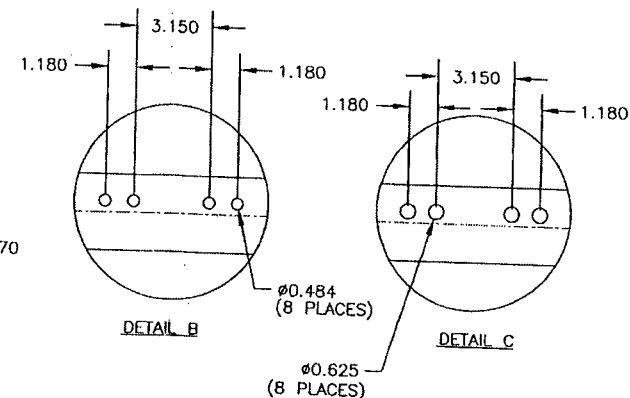
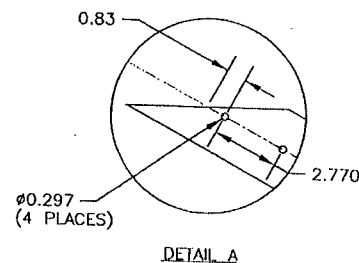
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DEOS	DEC 11 1997
	DEC 10 1997
	DEC 10 1997



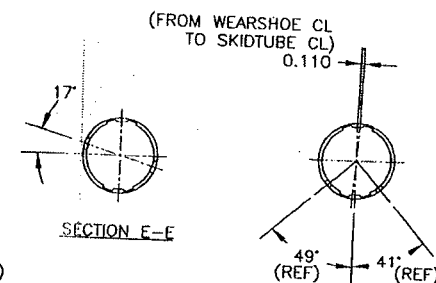
D2750-1 LH SKIDTUBE (SHOWN)  
D2750-2 RH SKIDTUBE (OPPOSITE)



D2750-3 LH SKIDTUBE (SHOWN)  
D2750-4 RH SKIDTUBE (OPPOSITE)  
D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



DETAIL D  
(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



SECTION F-F

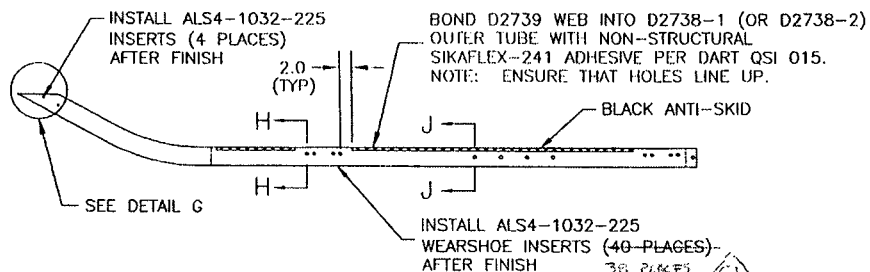
RELEASED  
98.12.16 DS

EFFECTIVE	DEOS
000 9133 98.01.19 DS	000 9133 99.02.21 DS

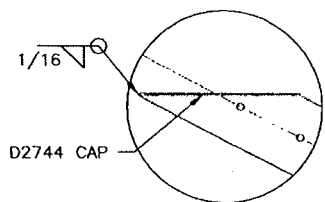
DESIGN D2750	DRAWN BY P	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED P	APPROVED HE	
DATE 98.11.18	DRAWING NO. D2750	REV. C SHEET 3 OF 4
	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

26  
104

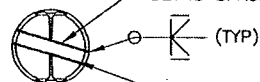
**D2750-1/-2/-3/-4 WELDING DETAIL**  
(FLOAT ATTACHMENT HOLES REMOVED)  
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



DETAIL G



SECTION H-H



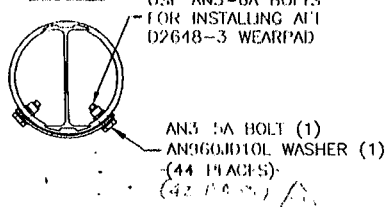
SECTION J-J



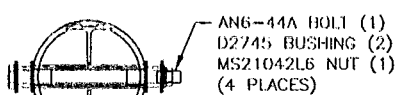
**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

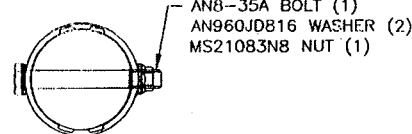
DETAIL K



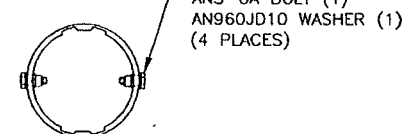
DETAIL M



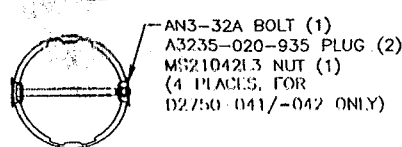
DETAIL P



DETAIL Q



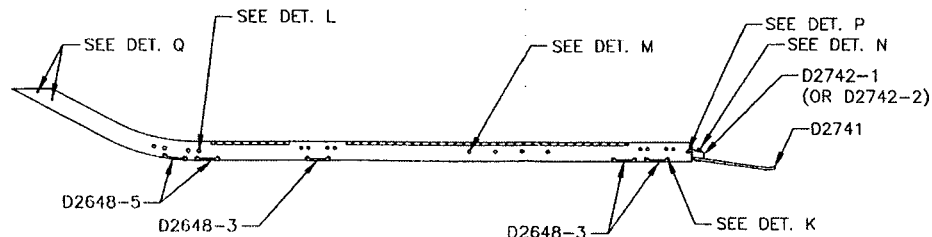
DETAIL L



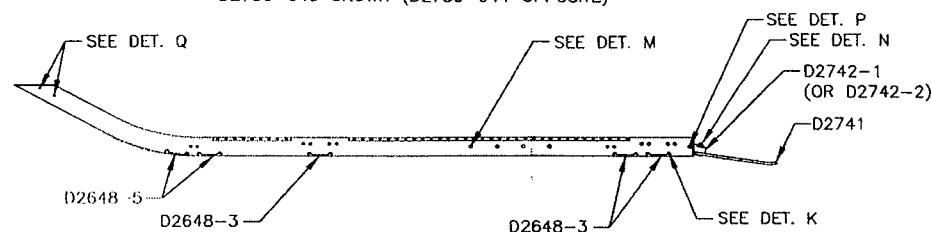
DETAIL N



**D2750-041/-042 ASSEMBLY**  
D2750-041 SHOWN (D2750-042 OPPOSITE)



**D2750-043/-044 ASSEMBLY**  
D2750-043 SHOWN (D2750-044 OPPOSITE)

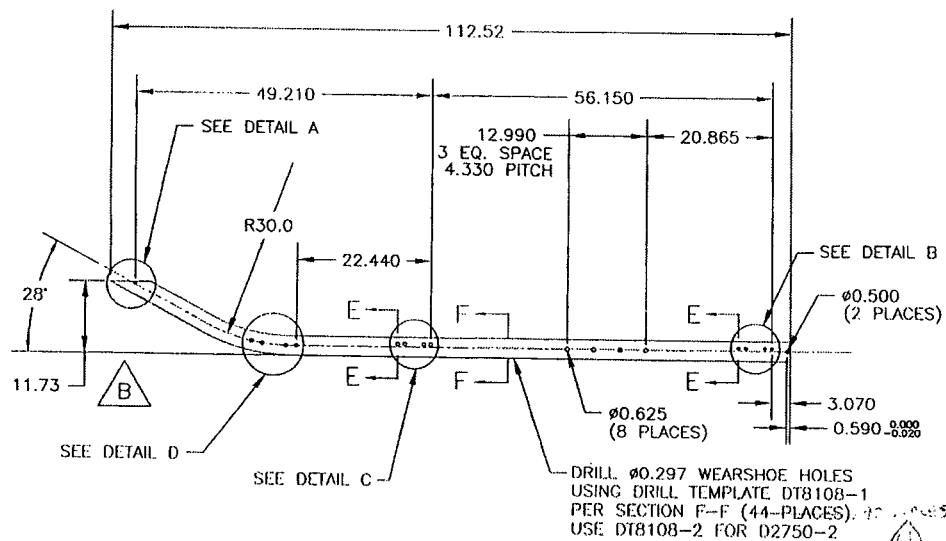


**RELEASED**  
98.12.16 DS

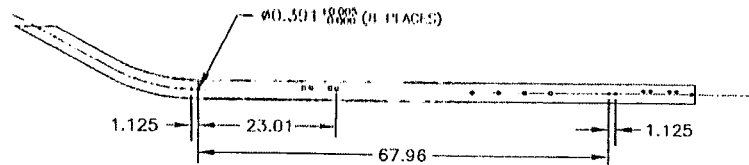
EFFECTIVE	DEQs
98.01.19 DS	98.10.21 DS

DESIGN <i>JP</i>	DRAWN BY <i>CP</i>	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA	
CHECKED <i>JP</i>	APPROVED <i>KE</i>		DRAWING NO. D2750
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SHEET 4 OF 4 SCALE 1:20

26104

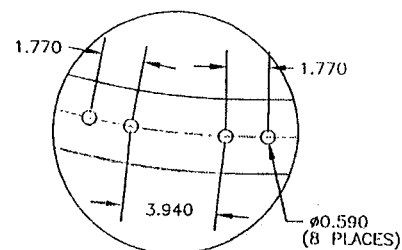
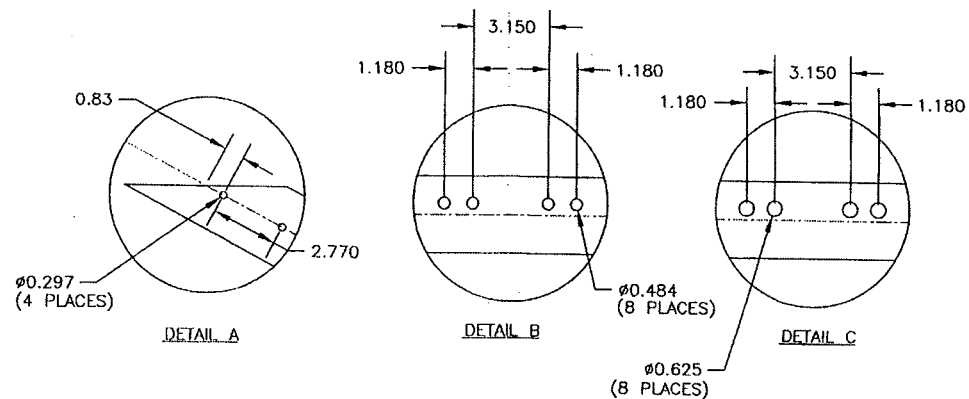


D2750-1 LH SKIDTUBE (SHOWN)  
D2750-2 RH SKIDTUBE (OPPOSITE)

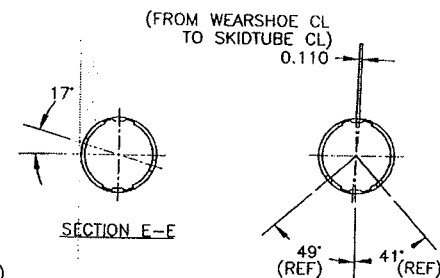


D2750-3 LH SKIDTUBE (SHOWN)  
D2750-4 RH SKIDTUBE (OPPOSITE)

D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



DETAIL D  
(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)



RELEASED  
98.12.16 DS

EFFECTIVE	DEOs
000 4133 98.01.19 DS	000 4137 99.02.21 DS

DESIGN DT	DRAWN BY CP	<b>DART</b> DART AEROSPACE USA, INC. BOLLENE, WA
CHECKED DT	APPROVED KE	DRAWING NO. D2750
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY
		REV. C SHEET 3 OF 4 SCALE 1:20

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